

# Work Order ID 53757

November 17, 2009 8:34:34 AM



Page 1

Item ID: D3953-3

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Stud, Lid

Start Date: 11/17/09 Start Qty: 20.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3953

A

100

0.00



Doosan

Doosan Lathe

Memo

Turn as per folio FA852 & DWG

FOLIO REV: AM

DWG REV: A

0.00

*del 09.11.19*

DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*del 09.11.19* 24 24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 53757

November 17, 2009 8:34:34 AM



Page 2

Item ID: D3953-3

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Setup Start



Revision ID: A

Stop



Item Name: Gas Spring Stud, Lid

Start Date: 11/17/09 Start Qty: 20.00



Cust Item ID:

Required Date: 11/20/09 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

SB 09/11/20

24



QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

CL 09/11/20 24

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/20 MF 09-11-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

November 17, 2009 8:34:33 AM

Page 1

Work Order ID: 53757

Parent Item: D3953-3

Parent Item Name: Gas Spring Stud, Lid

Comments: IPP RevA: New issue 09.10.13 DD verified by:EC

Start Date: 11/17/09

Required Date: 11/20/09

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304RO.750		Purchased	No			100	f	14.2300	2.6316			



304 SS Roundbar .750

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	14.23	
109421	1.39	
110166	1.44	
110912	6.06	
111323	3.5	
111988	1.84	

*Handwritten:* 11-17-09 11-13216 1.4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

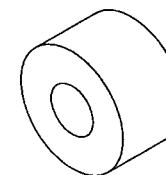
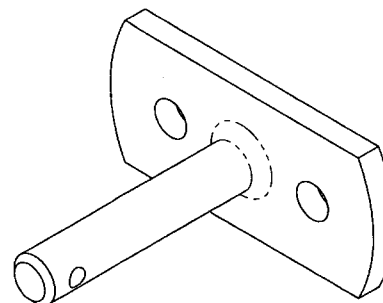
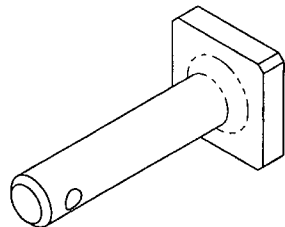
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





WLB  
53757

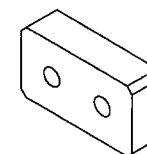
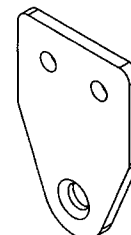
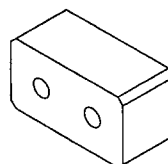
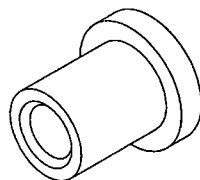
**D3953-1 GAS SPRING BRACKET**  
(FULL LID)

**D3953-3 GAS SPRING STUD, LID**

**D3953-5 GAS SPRING STUD, BASE**

**D3953-7 GAS SPRING SPACER**

**D3953-9 GAS SPRING WASHER**



**D3953-11 GAS SPRING SPACER**

**D3953-13 GAS SPRING SPACER**  
(FULL LID)

**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)

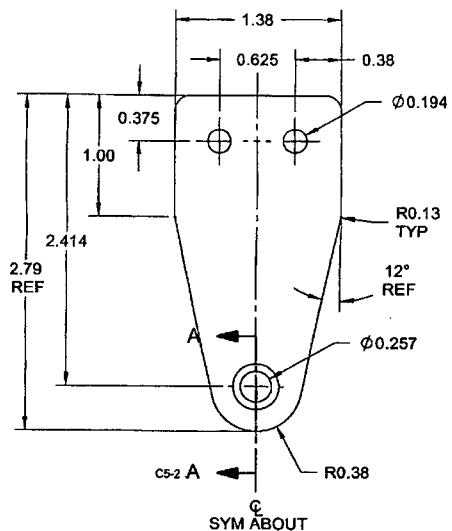
**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)

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2009 -10- 08

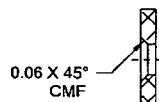
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REV.	DESCRIPTION	BY	DATE
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3953	SHEET 1 OF 4
APPROVED		TITLE	SCALE
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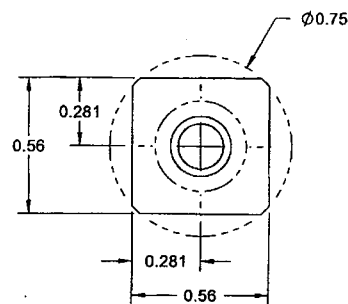
W053757



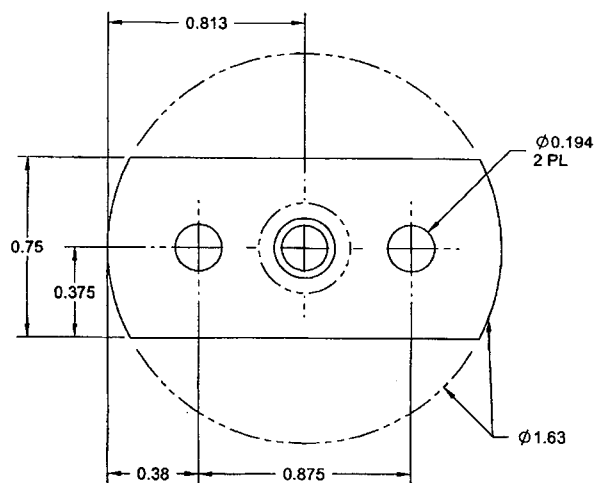
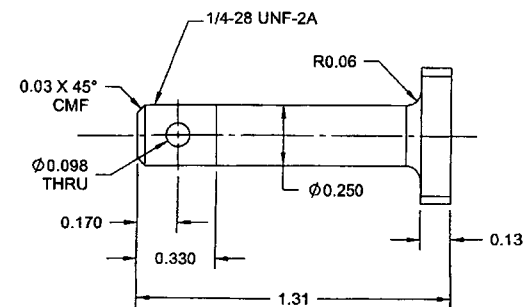
**D3953-1 GAS SPRING BRACKET**  
(FULL LID)



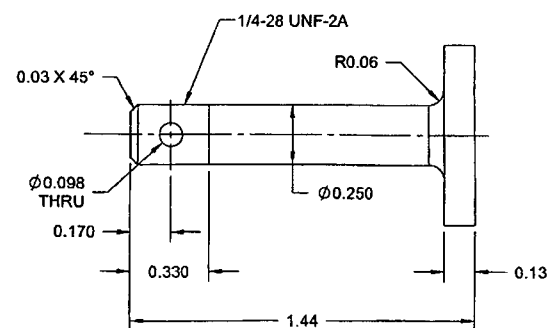
**SECTION A-A** C7-2



**D3953-3 GAS SPRING STUD, LID**



**D3953-5 GAS SPRING STUD, BASE**



**NOTES:**

1) MATERIAL -1: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK  
REF DART SPEC M304S

-3 & -5: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

OR: AISI 304/316 STAINLESS STEEL ROD  
REF DART SPEC M304R

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX





6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER

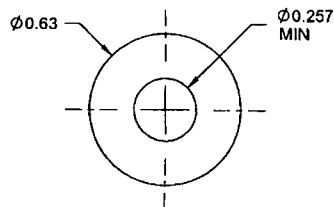
7) WEIGHT -1: 0.11 lbs

-3: 0.03 lbs

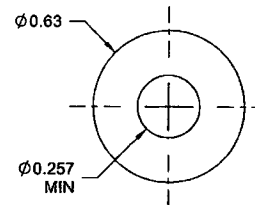
-5: 0.06 lbs

**RELEASED**  
2009-10-08

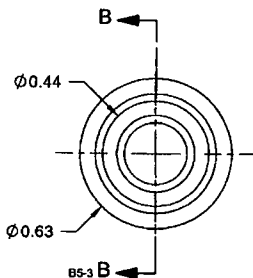
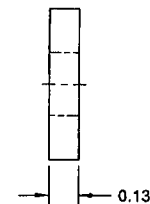
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3953	SHEET 2 OF 4
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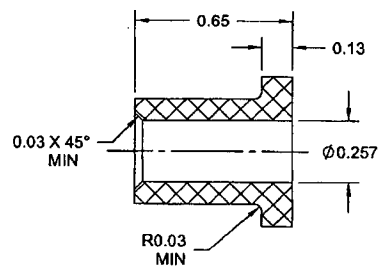
**D3953-7 GAS SPRING SPACER**



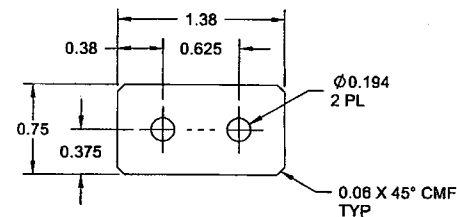
**D3953-9 GAS SPRING WASHER**



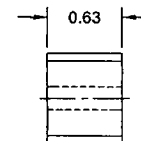
**D3953-11 GAS SPRING SPACER**



**SECTION B-B** B7-3



**D3953-13 GAS SPRING SPACER**



**RELEASED**  
2009-10-08

**NOTES:**

1) MATERIAL -7,-9 & -11: DELRIN II 150E OR ACETRON GP ACETAL, BLACK  
REF DART SPEC M-DELRIN-R

-13: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

2) FINISH: N/A

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

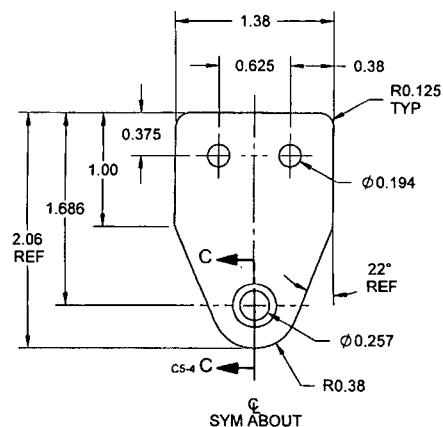
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION -13 ONLY: IDENTIFY WITH DART P/N "D3953-13" USING FINE POINT PERMANENT INK MARKER

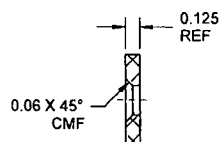
7) WEIGHT -7/-9/-11: < 0.01 lbs EACH

-13: 0.17 lbs

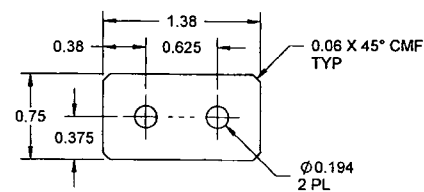
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>[Signature]</i>	D3953	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GAS SPRING LID COMPONENTS	NTS
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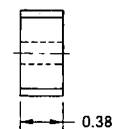
**D3953-15 GAS SPRING BRACKET**  
(SPLIT LID)



**SECTION C-C** C7-4



**D3953-17 GAS SPRING SPACER**  
(SPLIT LID)







**NOTES:**

1) MATERIAL -15: MATERIAL: AISI 304 STAINLESS STEEL SHEET, 0.125 THICK  
REF DART SPEC M304S

-17: AISI 304 STAINLESS STEEL BAR  
REF DART SPEC M304B

- 2) FINISH: N/A  
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
4) UNITS: INCHES UNLESS OTHERWISE NOTED  
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3953-X" USING FINE POINT PERMANENT INK MARKER  
7) WEIGHT -15: 0.08 lbs  
-17: 0.10 lbs

**RELEASED**  
2009-10-08

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D3953	SHEET 4 OF 4
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